

**Claims:**

1. Method for the production of a lighting element  
comprising at least one luminescent diode and an  
5 inserted light-guiding body, which is arranged in  
front of said luminescent diode in the direction of  
the exit of the main light, wherein the respective  
luminescent diodes are connected to the inserted  
light-guiding body by an injection molding process  
10 with transparent plastic, said method being  
characterized in that,
  - at least 50% of the surface (12) of the light-  
emitting diodes is covered by the injected  
material (30) during injection molding, and
  - 15 - that the maximum wall thickness of the injected  
layer (30) does not exceed three-times the  
minimum wall-thickness of said layer (30).
2. Method according to claim 1, characterized in that the  
20 lower edge (32) of the injected layer (30) engaging  
radially around the surface (12) of the light-emitting  
diode ends below a plane, which runs normal to the  
centerline (7) of the luminescent diode (11) and  
through the center of gravity of the light-emitting  
25 chip (6) of this luminescent diode (11).
3. Method according to claim 1, characterized in that the  
luminescent diode (11) and the inserted light-guiding  
body (21) are located on a common centerline (7),  
30 wherein the centerline (7) runs through the center of

gravity of the light-emitting chip (6) of the luminescent diode (11).

4. Method according to claim 1, characterized in that the  
5 lighting element (70) is made of several individual lighting elements (10) arranged adjoining to one another.
5. Method according to claim 4, characterized in that the  
10 centerlines (7) of the individual lighting elements (10) are arranged parallel to one another or intersect in an at least partially fan-like manner at one or more points located behind the lighting element (70) or intersect at a short distance.
- 15 6. Method according to claim 1, characterized in that the inserted light-guiding body (21) comprises a concave recess (25) towards the diode (11).
- 20 7. Method according to claim 1, characterized in that a light lens (40) for designing a main light exit surface (41) is molded into the combination of the diode (11), the inserted light-guiding body (21) and the injected layer (30) in an additional injection  
25 molding step.
8. Method according to claim 7, characterized in that the light lens (40) is a diffusing screen.
- 30 9. Method according to claim 1 and 8, characterized in that the inserted light-guiding body (21) has a

different color than that of the diffusing screen (40).

10. Method according to claim 1, characterized in that at least one substance is admixed to the material of at least one component (11, 21, 30, 40), wherein said substance emits a light of another wavelength when excited by the light emitted from the chip (6).
- 10 11. Method according to claim 1, characterized in that the luminescent diodes (11) are fixed on a circuit board before the coating by means of injection molding.